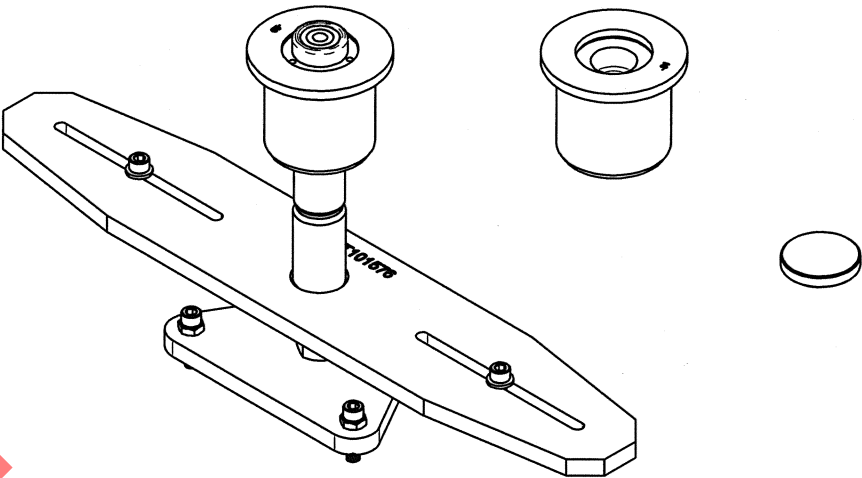
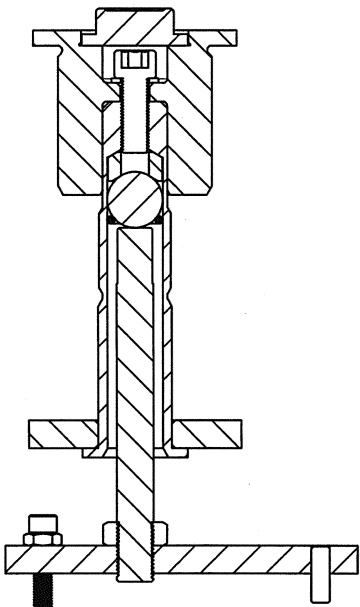


ITEM #	QTY	PART #	PART TITLE
-3	1	RB T101576-3	MANDREL ASSY
-7	1	RB T101576-7	STAND ASSY
-13	1	RB T101576-13	BASE
-19	1	RB T101576-19	PLATE
-29	1	RB T101576-29	206 PLUG
-31	1	RB T101576-31	206L PLUG
32	1	McMaster#2198A860 OR EQUIV.	HIGH-TEMP. CIRCULAR MOUNTABLE LEVEL 1-7/16" BASE DIA. X 1/2" OVERALL HT.
33	2	McMaster#92185A564 OR EQUIV.	SS SOCKET HEAD SCREW 1/4"-28 X 1" LG.
34	1	McMaster#92185A673 OR EQUIV.	SS SOCKET HEAD SCREW 3/8"-24 X 1" LG.
35	2	NAS1149C0463R	WASHER
36	1	NAS1149C0663R	WASHER



RB T101576 BALANCE SET



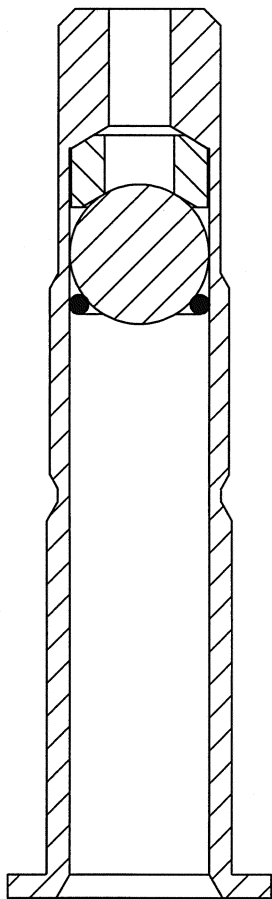
(THIS VIEW IS SHOWN FOR REFERENCE ONLY)

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

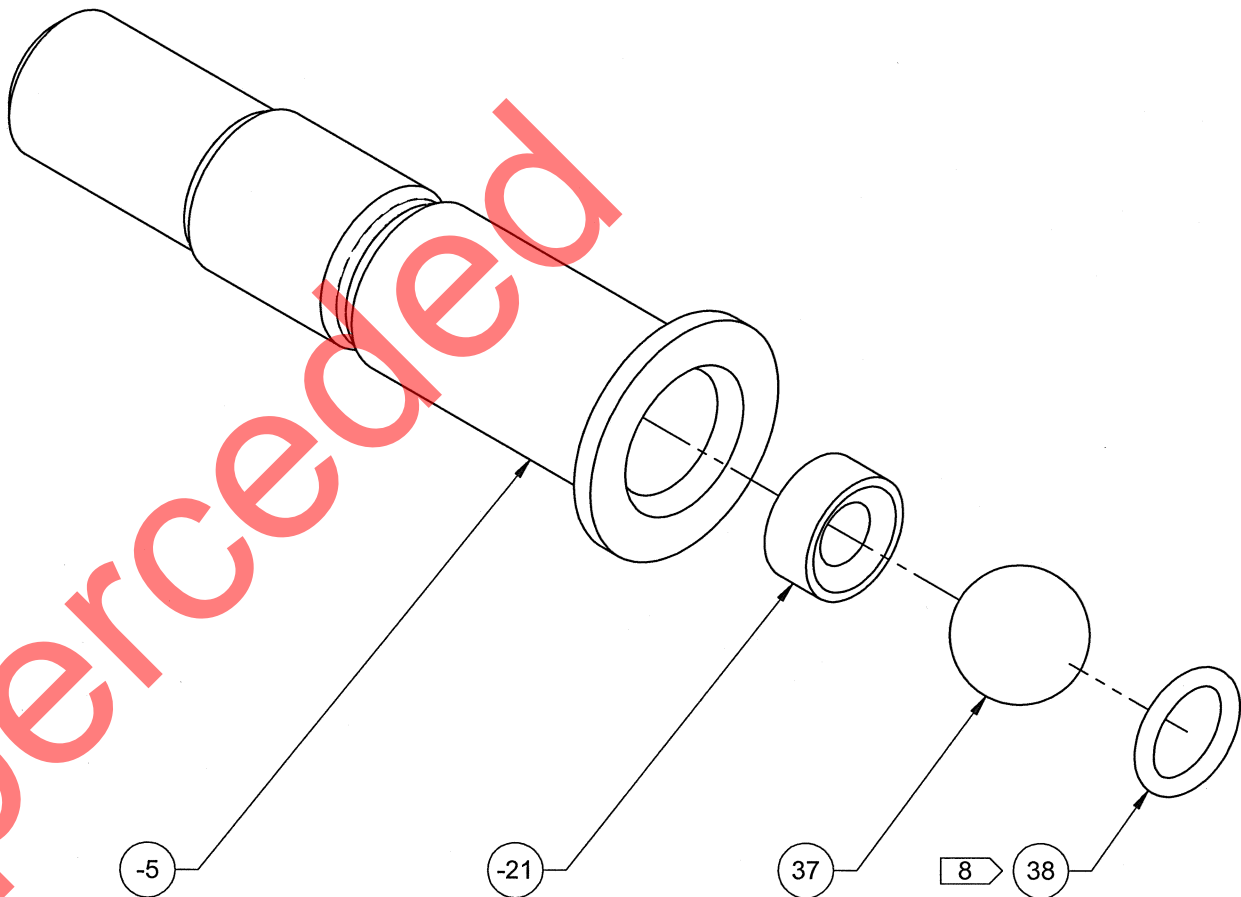
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN
8) APPLY LOCTITE LB 771 NICKEL BASED ANTI SEIZE ON THREADS OF ITEM 34 THEN ASSEMBLE WITH ITEM -3
9) INSTALL ITEM 34 HAND TIGHT
10) ASSEMBLE TOOL WITH ITEM -29
11) ITEM -31 MUST BE INDIVIDUALLY PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG
12) ITEM -19 MUST BE INDIVIDUALLY PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG
13) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

UPDATED DRAWING TEMPLATE AND HARDWARE DASH NUMBERS TOOL TITLE WAS "BALANCE SET - MAIN & TAIL ROTOR" IS "BALANCE SET" ITEM 32 WAS GEIER & BLUHM #2-14000 IS McMaster#2198A860 OR EQUIV. ITEM 35 WAS MCMaster-CARR#98017A660 IS NAS1149C0463R ITEM 36 WAS MCMaster-CARR#98017A200 IS NAS1149C0663R ITEM 37 WAS MCMaster-CARR#9528K29 IS McMaster#9642K63 OR EQUIV. ITEM 40 WAS MCMaster-CARR#90257A033 IS McMaster#94805A224 OR EQUIV. ITEM 41 WAS MCMaster-CARR#94805A217 IS McMaster#94805A224 OR EQUIV. ITEM 42 WAS MCMaster-CARR#97395A485 IS McMaster#98380A540 OR EQUIV. -5 REMOVED UNDERCUT. DIM WAS $\phi .752 \pm .751$ IS $\phi 0.7525-0.7510$. DIM WAS R.010 MAX TYP IS R0.008 MAX 5 PL -9 DIM WAS $\phi .510-.436$ IS $\phi 0.473$. DIM WAS R.010 MAX IS R0.008 MAX -11 DIM WAS $\phi .249-.248$ IS $\phi 0.250+0.000/-0.001$ -13 DIM WAS .255-.250 IS 0.260-0.255 2 PL -21 DIM WAS 30° IS 31.0° -29, -31 DIM WAS $\phi .396-.390$ THRU ALL $\angle \phi .491 \times 90^\circ$, NEAR SIDE DIM IS $\phi 0.397$ THRU 0.05 X 45.0° CMF, NEAR SIDE. ADDED 0.0015 FLATNESS GD&T CALLOUT. PERPENDICULARITY TOLERANCE WAS 0.0002 IS 0.0015			
REV.	DESCRIPTION		ECN #
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	FK	RB T101576	SHEET 1 OF 11
APPROVED		TITLE	SCALE
		BALANCE SET	NTS
DATE 18/04/2019		COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM #	QTY	PART #	PART TITLE
-5	1	RB T101576-5	MANDREL
-21	1	RB T101576-21	PLUG
37	1	McMaster#9642K63 OR EQUIV.	440C SS BALL 3/4" DIA.
38	1	McMaster#2857T128 OR EQUIV.	VITON O-RING 3/32 THK. X 9/16" ID. X 3/4" OD.



(THIS VIEW IS SHOWN FOR REFERENCE ONLY)



RB T101576-3 MANDREL ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY MOLYKOTE 55 OR EQUIVALENT ON ITEM 38 THEN ASSEMBLE WITH ITEM -5 AND REMOVE EXCESS

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	FK	RB T101576	SHEET 2 OF 11
APPROVED	<i>Mza</i>	TITLE	SCALE
DATE 18/04/2019		BALANCE SET	NTS
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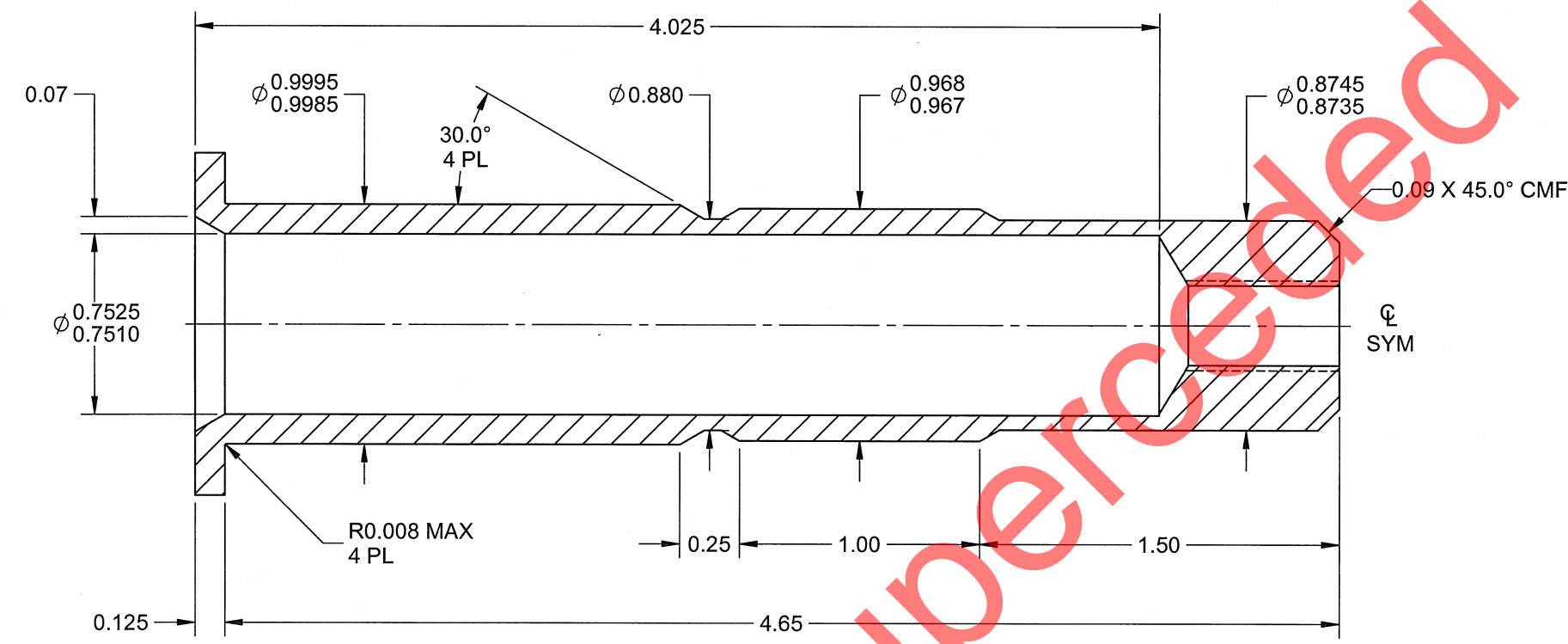
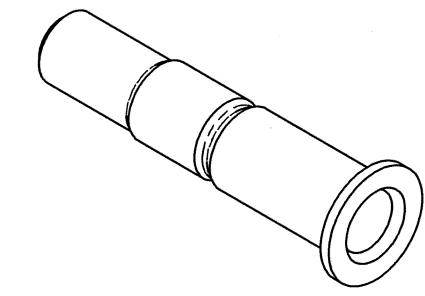
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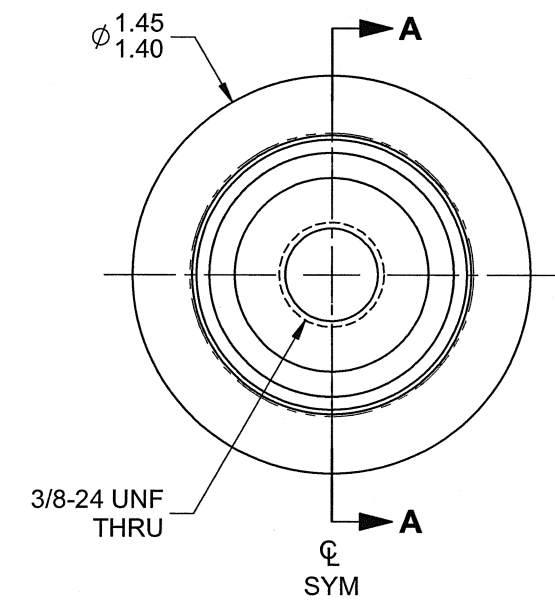
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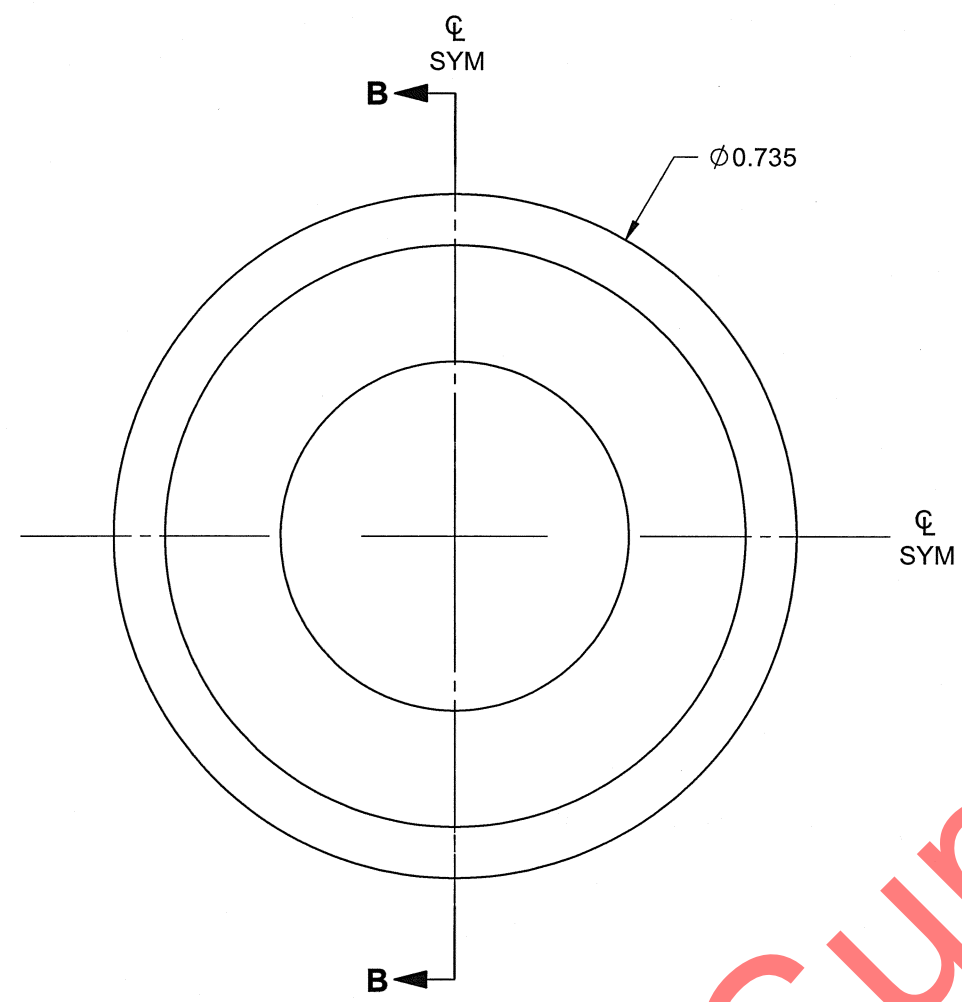
SECTION A-A



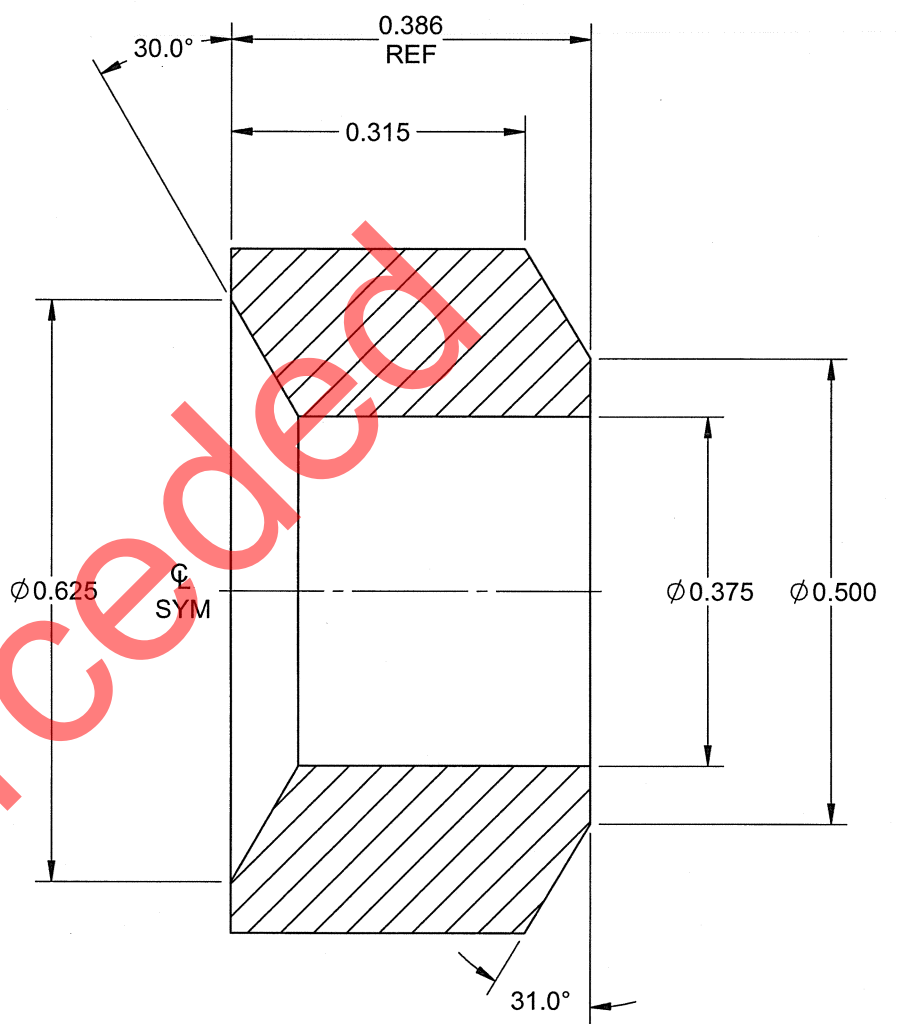
RB T101576-5 MANDREL

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

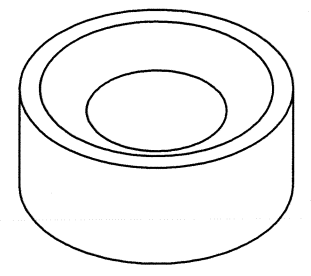
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	FK	RB T101576	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DATE 18/04/2019		BALANCE SET	NTS
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RB T101576-21 PLUG



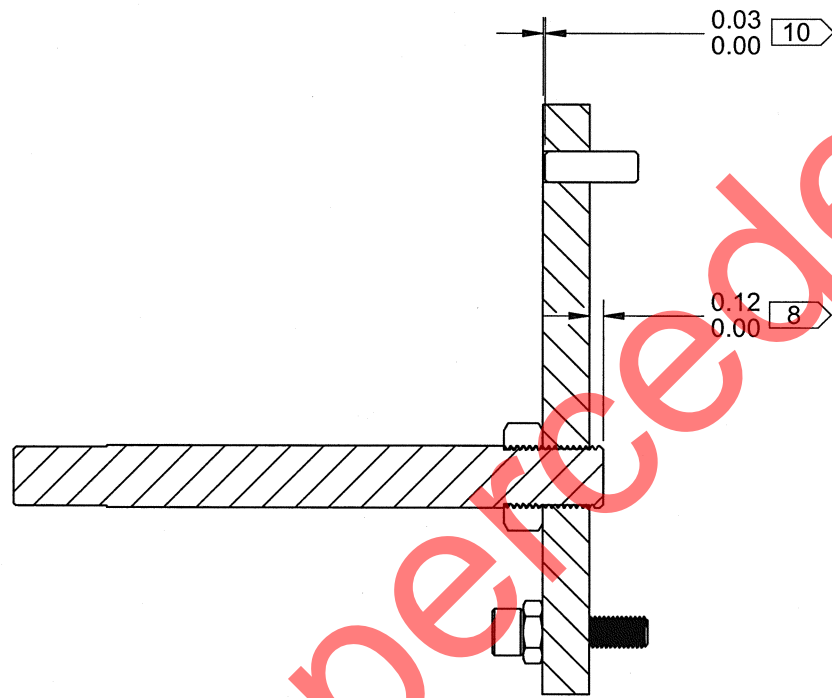
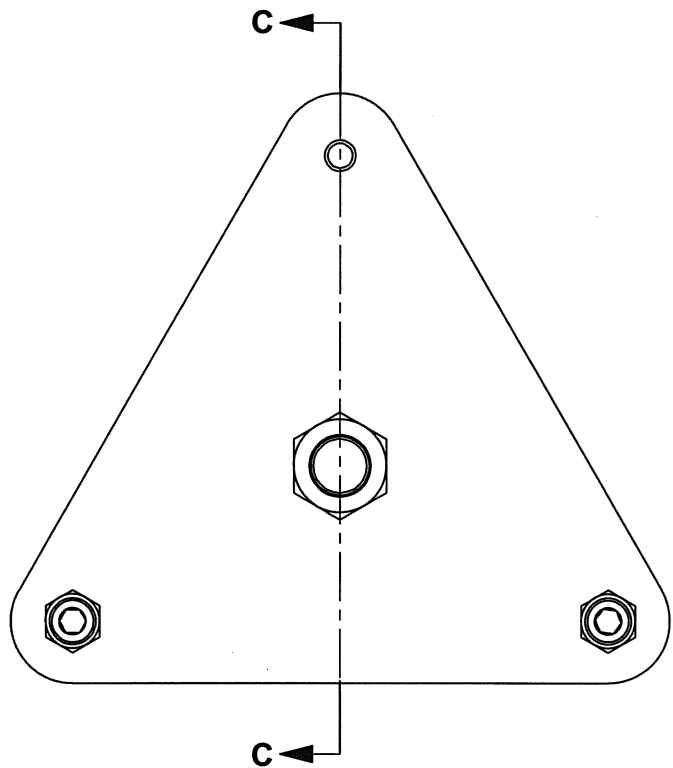
SECTION B-B



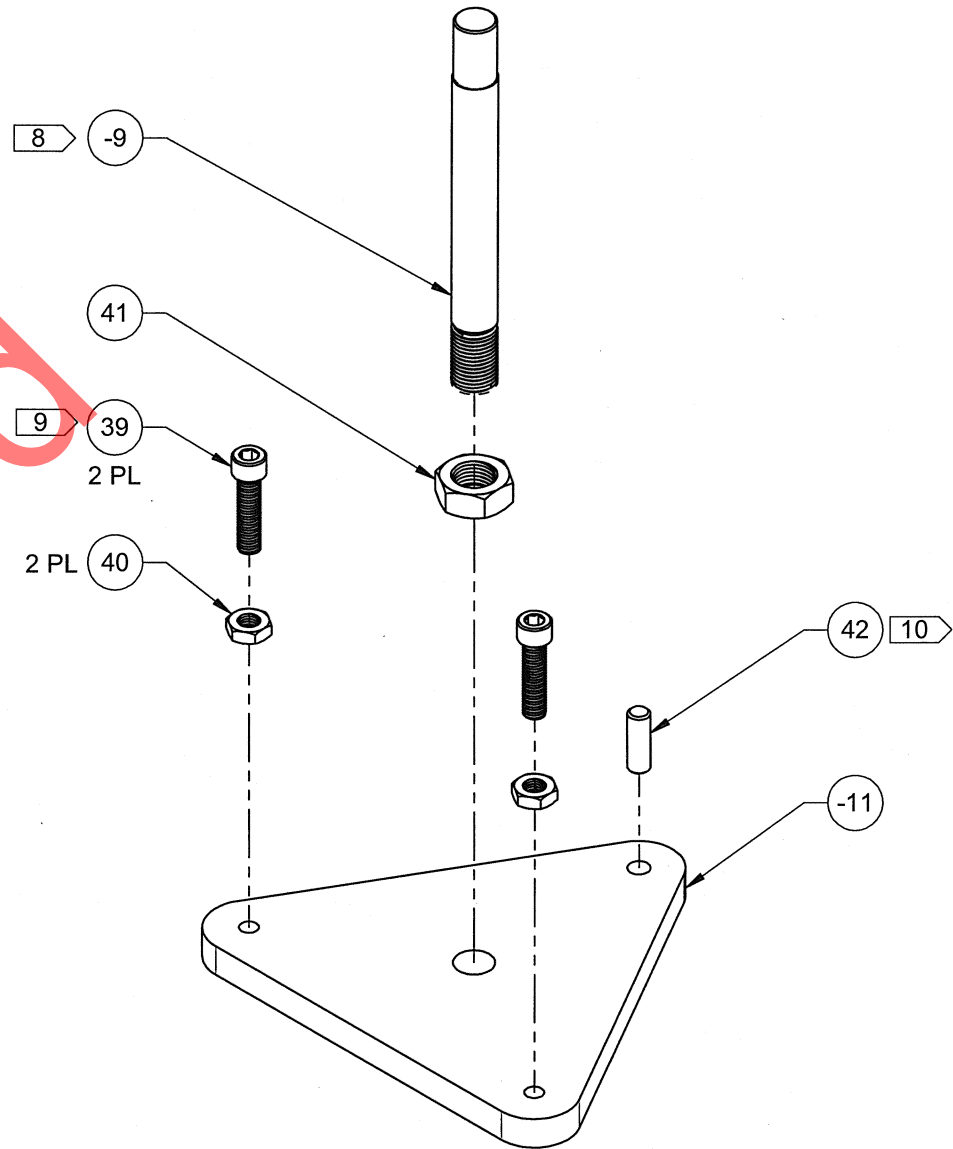
- NOTES:
- 1) MATERIAL: STAINLESS STEEL 440C
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	FK	RB T101576	SHEET 4 OF 11
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE 18/04/2019		BALANCE SET	NTS
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ITEM #	QTY	PART #	PART TITLE
-9	1	RB T101576-9	STAND
-11	1	RB T101576-11	PLATE
39	2	McMaster#92185A564 OR EQUIV.	SS SOCKET HEAD SCREW 1/4"-28 X 1" LG.
40	2	McMaster#94805A209 OR EQUIV.	SS HEX NUT 1/4"-28 X 5/32" HT.
41	1	McMaster#94805A224 OR EQUIV.	SS HEX NUT 1/2"-20 X 5/16" HT.
42	1	McMaster#98380A540 OR EQUIV.	SS DOWEL PIN 1/4" DIA. X 3/4" LG.



SECTION C-C



RB T101576-7 STAND ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY LOCTITE LB 771 NICKEL BASED ANTI SEIZE ON THREADS OF ITEM -9 THEN ASSEMBLE WITH ITEM 41 AND ITEM -11 AS SHOWN
- 9) APPLY LOCTITE LB 771 NICKEL BASED ANTI SEIZE ON THREADS OF ITEM 39 THEN ASSEMBLE WITH ITEM 40 AND ITEM -11 AS SHOWN
- 10) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 41 WITH ITEM -11 AND REMOVE EXCESS

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	FK	RB T101576	SHEET 5 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
		BALANCE SET	NTS
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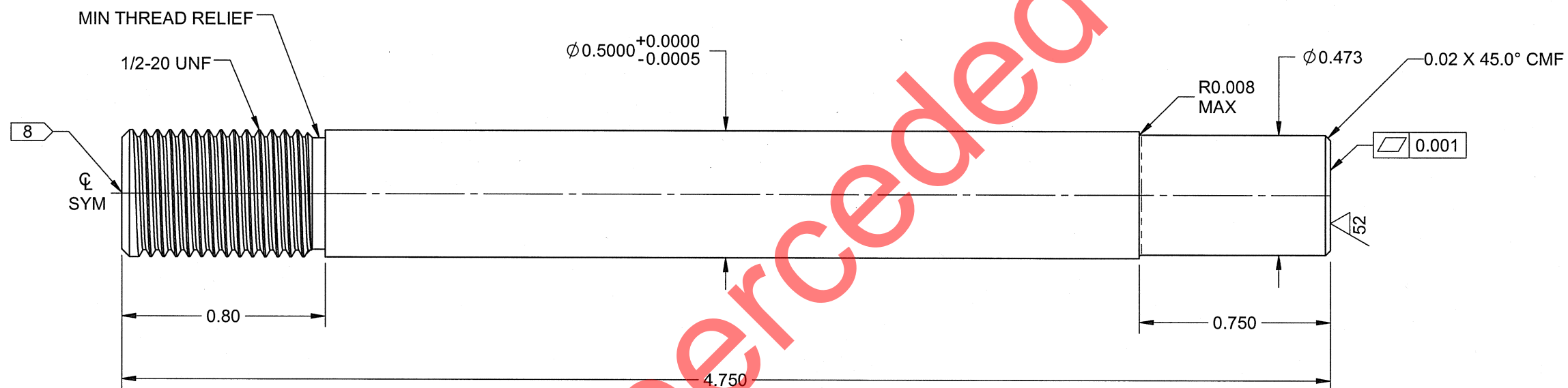
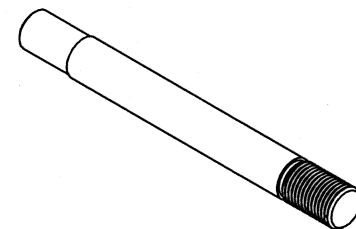
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RB T101576-9 STAND

NOTES:

1) MATERIAL: STAINLESS STEEL 440C

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

8) CENTER DRILL IS ACCEPTABLE

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	FK	RB T101576	SHEET 6 OF 11
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE 18/04/2019		BALANCE SET	NTS
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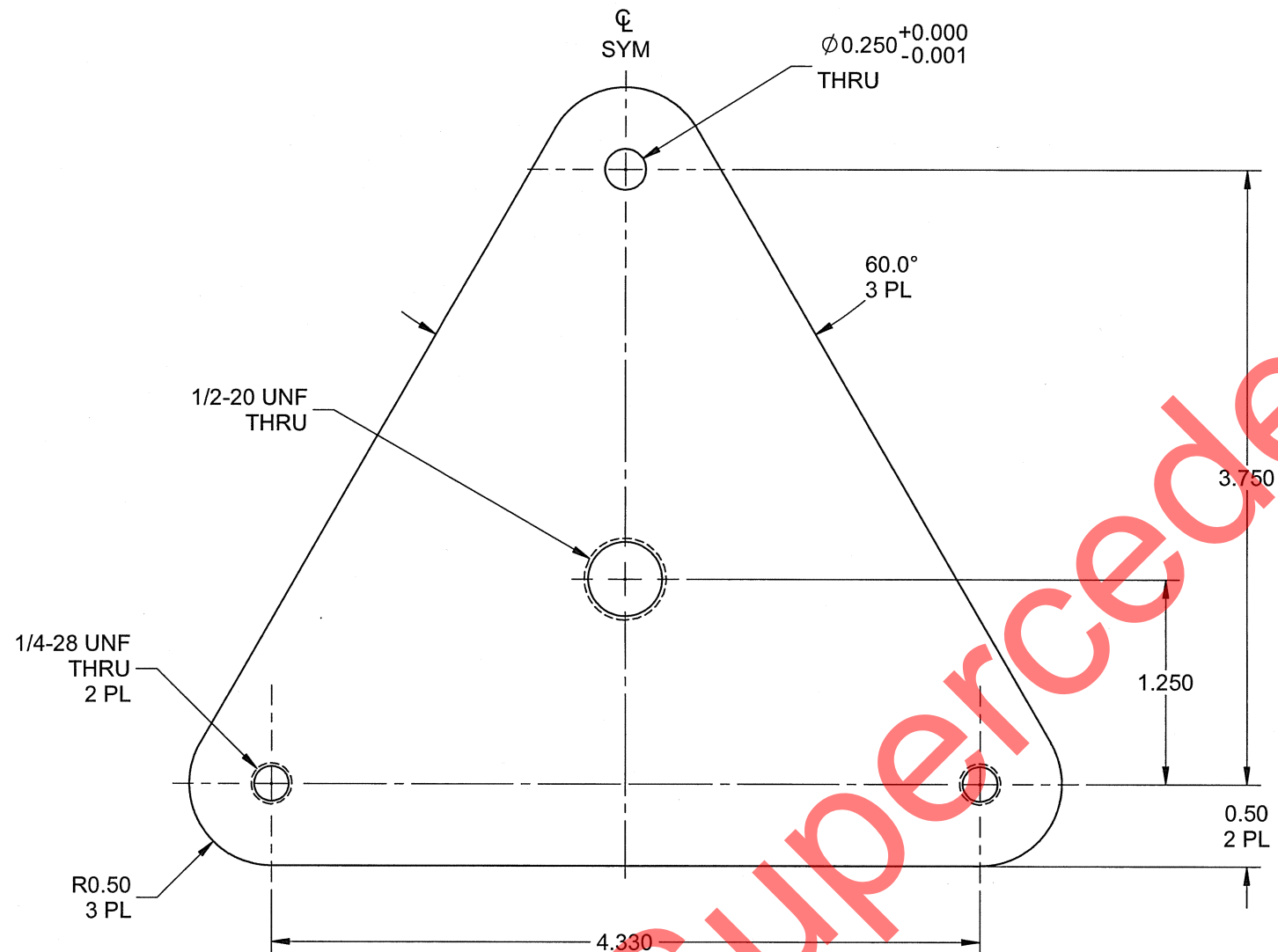
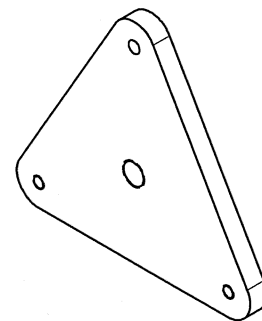
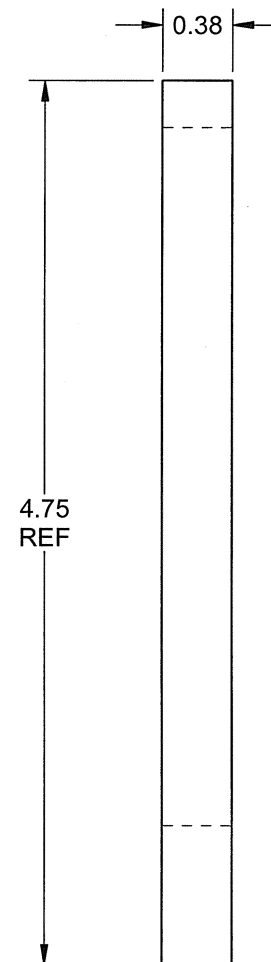
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**RB T101576-11 PLATE**

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NOTES:

1) MATERIAL: 303/304/316 STAINLESS STEEL

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

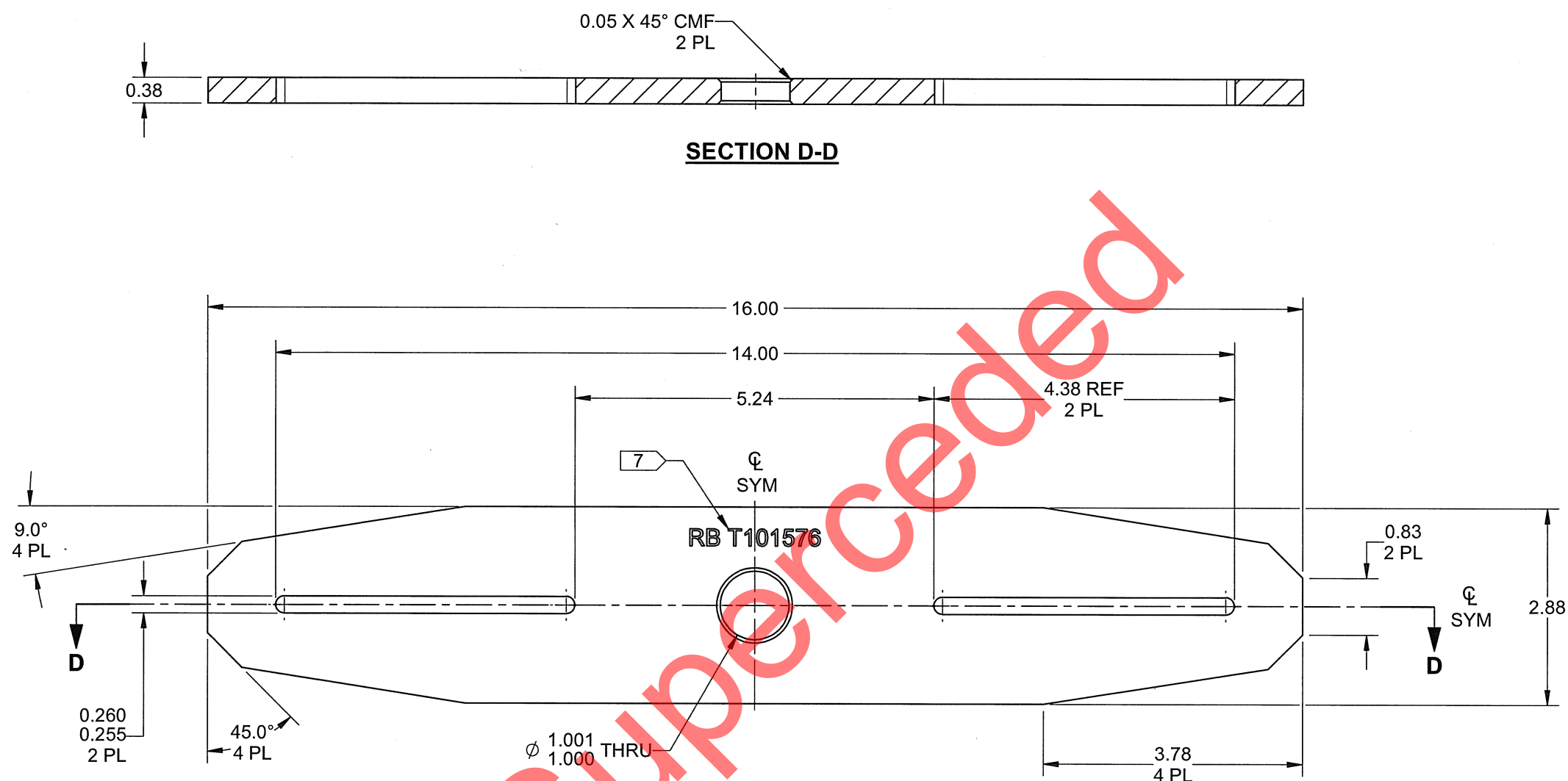
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	FK	RB T101576	SHEET 7 OF 11
APPROVED	<i>ML</i>	TITLE	SCALE
		BALANCE SET	NTS
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SECTION D-D

RB T101576-13 BASE

NOTES:

- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. 0
MFG. APPR.	FK	RB T101576	SHEET 8 OF 1
APPROVED		TITLE	SCALE
		BALANCE SET	NTS 
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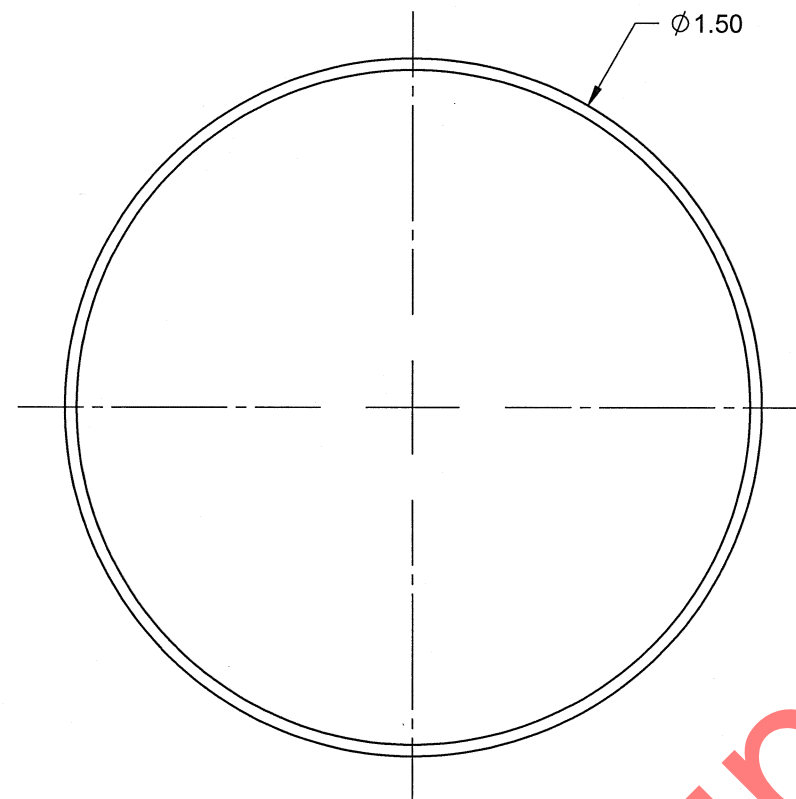
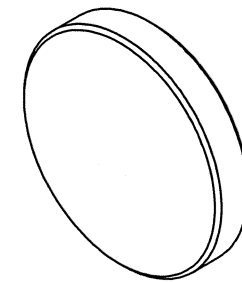
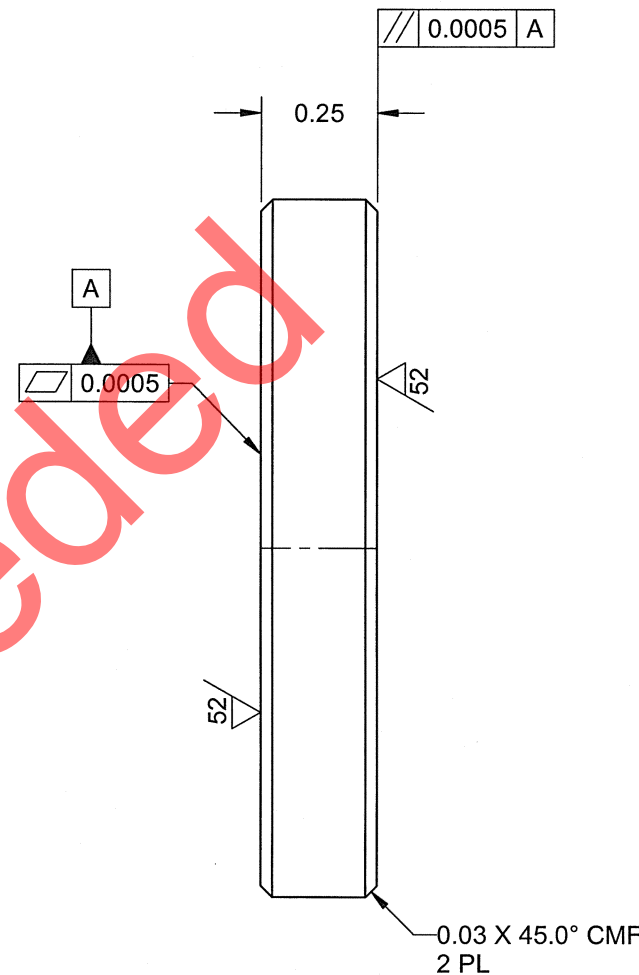
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**RB T101576-19 PLATE****NOTES:**

1) MATERIAL: 17-4PH-H900 STAINLESS STEEL

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	FK	RB T101576	SHEET 9 OF 11
APPROVED	<i>ML</i>	TITLE	SCALE
		BALANCE SET	NTS
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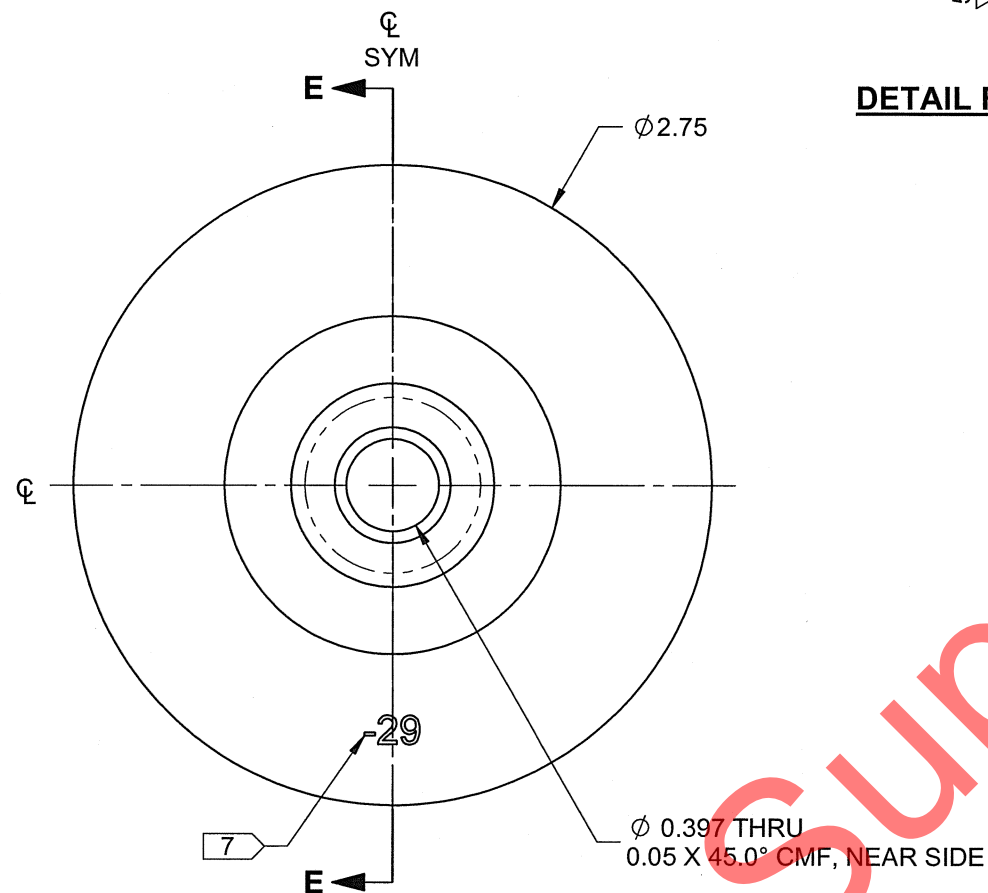
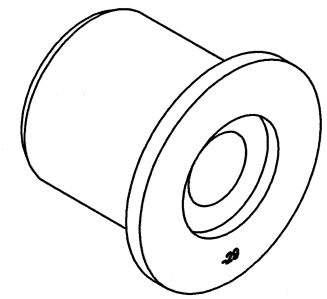
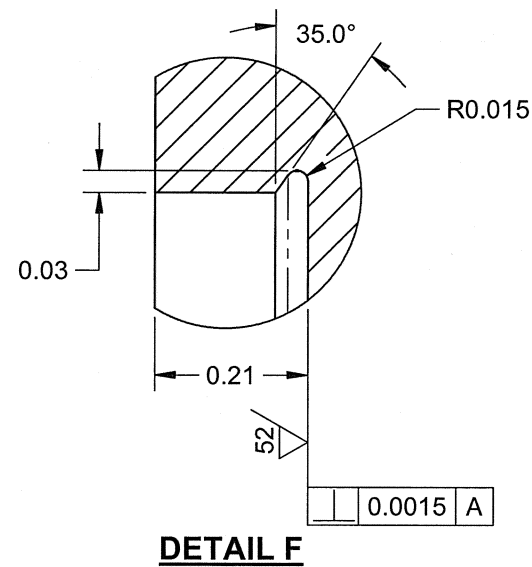
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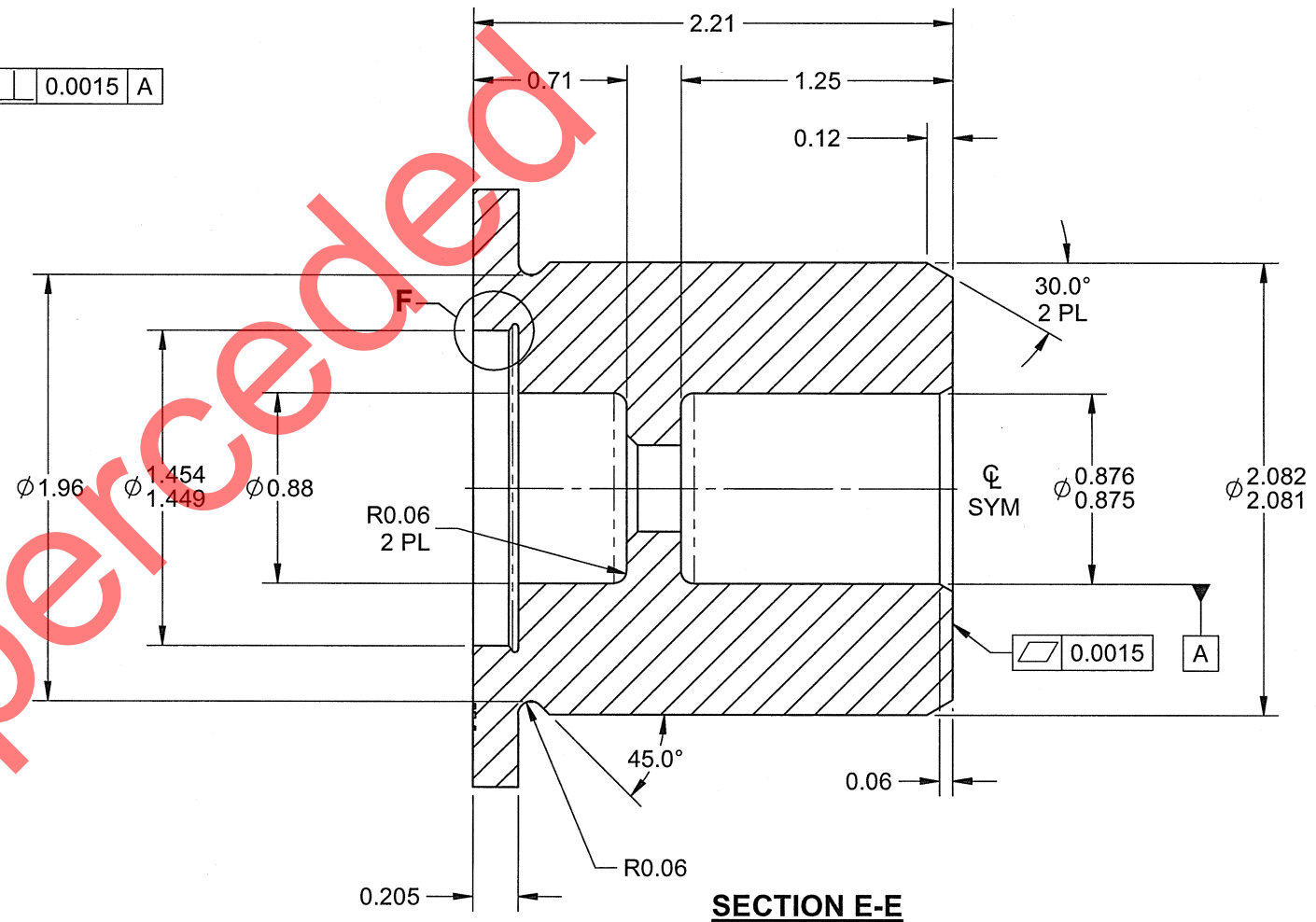
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RB T101576-29 206 PLUG



NOTES:

1) MATERIAL: 303/304/316 STAINLESS STEEL

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

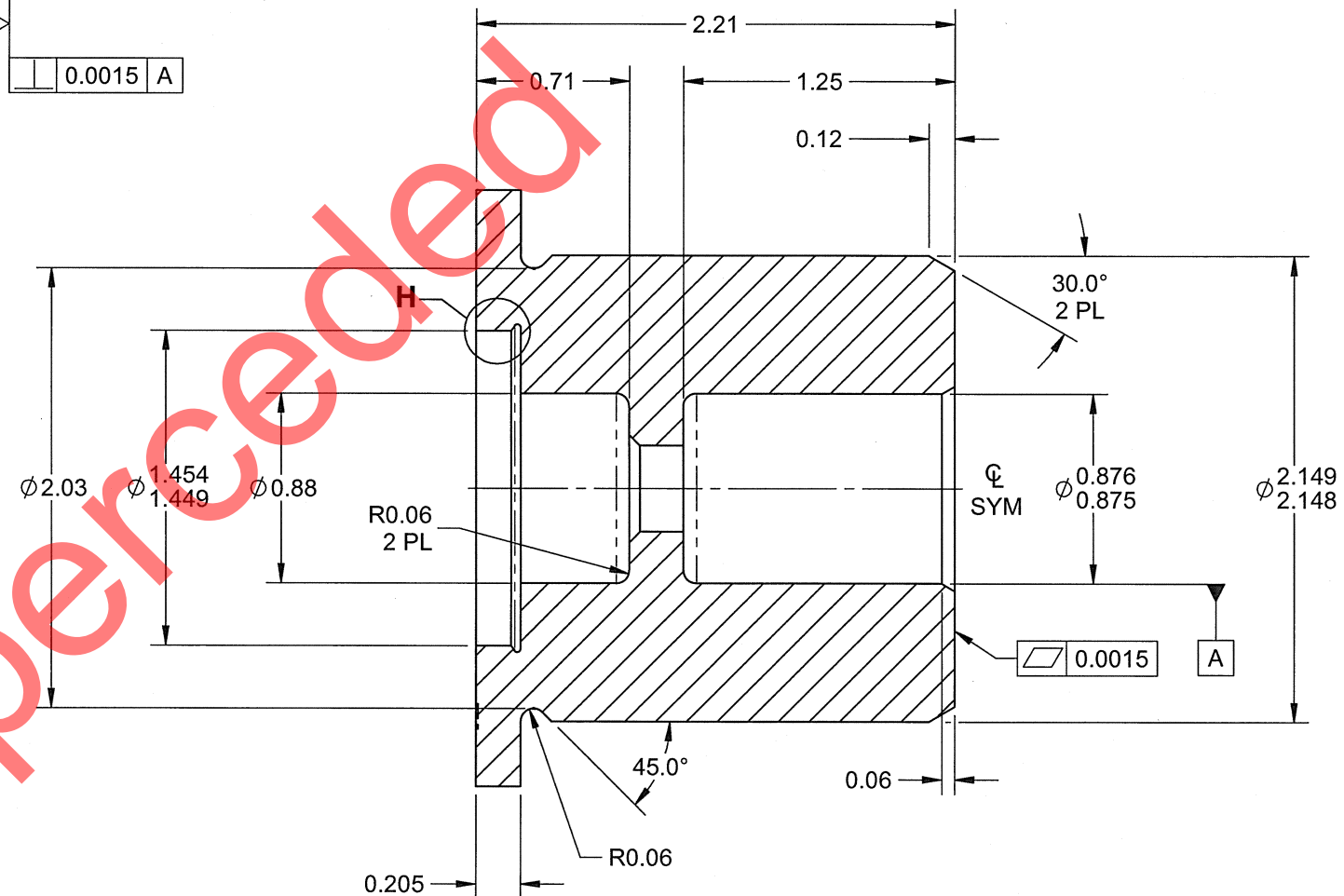
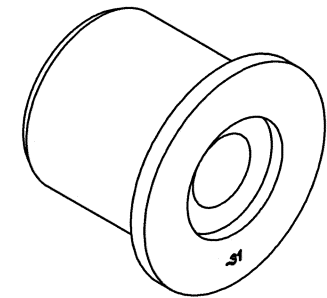
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK AS SHOWN


DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	FK	RB T101576	SHEET 10 OF 11
APPROVED		TITLE	SCALE
		BALANCE SET	NTS
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SECTION G-G

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	FK	RB T101576	SHEET 11 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
		BALANCE SET	NTS 
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